

# Work Order ID 74633

Tuesday, October 04, 2011 1:42:19 PM

Page 1

Item ID: D3913-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: M C J

Date: 11/10/04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100

Weld per dwg A/R S.S. rod Batch: 119649 0.00



Large Fab

Memo

0.00

Large Fab

1- assemble ribs, weld as per dwg D3913 using DT9610A  
\*\*\*inspect before welding mesh\*\*\*  
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PC 11.10.11

1x

BE  
11.10.12

1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8/10/13

FD

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX Ø m / 10/11/13

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\*2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

IX Ø M-11/10/13

M118439

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 of 11/10/13

Dart Aerospace Ltd

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Pick Kit

1 0 11/10/13

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8-11/10/13



170

Identify as per dwg &amp; Stock Location w/o

0.00



Packaging

Memo

0.00

Packaging

D4030-041/B74629 1 0 11/12/13

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Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/11 [Signature]

11.10.14

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Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
chg qty's DD 10.04.12 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																																				
D2581  Mounting Bracket		Manufactured	No			100	Each	18.0000	2	2		11-10-05																																																																																					
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69739	2																																																																																																
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73079	14																																																																																																
D3913-1  Rib		Manufactured	No			100	Each	4.0000	1	1		11-10-05																																																																																					
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D3913-15  Wide Handle Plate		Manufactured	No			100	Each	1.0000	1	1		11-10-06																																																																																					
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B74317 → ①

B74317 → ①

**Dart Aerospace Ltd**

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Work Order ID: 74633

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3913-3



Rib

Manufactured No

100

Each

3.0000

1



1

*PL 11.10.05*

Location

Loc Qty

Loc Code

WA

3

69160

1

73533

2

100

Each

4.0000

2



2

*PL 11.10.05*

*B73648 → ②*

D3913-7



Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

2

69521

2

WA006

2

65278

1

66435

1

100

Each

3.0000

1



1

*PL 11.10.05*

D3913-9



Hinge Rib

Manufactured No

Location

Loc Qty

Loc Code

WA

2

73530

2

WA006

1

70138

1

100

Each

2.0000

2



2

*PL 11.10.05*

*B74131 → ②*

D3916-041



Rib Assembly

Manufactured No

Location

Loc Qty

Loc Code

WA

2

69161

2

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**Dart Aerospace Ltd**

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3916-5

Manufactured No

100

Each

5.0000

3

3



Light Rib



6/11/10.05

Location

Loc Qty

Loc Code

WA

5

73637

5

③

D4016-1

Manufactured No

100

Each

13.0000

3

3



Hinge Half, Base



6/11/10.05

Location

Loc Qty

Loc Code

WA

13

66418

0

68426

3

72757

10

③

D4017-7

Manufactured No

100

Each

1.0000

1



Rib



6/11/10.05

Location

Loc Qty

Loc Code

WA

1

69730

1

374077 → ①

D4017-9

Manufactured No

100

Each

8.0000

2

2



Rib



6/11/10.05

Location

Loc Qty

Loc Code

WA

8

70341

2

73531

6

②

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**Dart Aerospace Ltd**

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Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-11



End Mesh, Basket

Manufactured No

100

Each

7.0000

2

2



*Pl 11.10.07*

Location

Loc Qty

Loc Code

WA

7

69648

2

74035

5

*(2)*

D4021-1



Handle Plate

Manufactured No

100

Each

12.0000

3

3



*Pl 11.10.05*

Location

Loc Qty

Loc Code

WA

6

69518

6

WA005

6

73649

6

*(3)*

D4034-041



Aft Upper Rib Assembly

Manufactured No

100

Each

2.0000

1

1



*Pl 11.10.05*

Location

Loc Qty

Loc Code

WA

1

73933

1

WA006

1

69157

1

*(1)*

D4034-043



Fwd Upper Rib Assembly

Manufactured No

100

Each

2.0000

1

1



*Pl 11.10.05*

Location

Loc Qty

Loc Code

WA

1

73934

1

WA006

1

70241

1

*(1)*

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Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

571.3581

33

33



Expanded Metal Flat SS



33  
11-10-11

Location

Loc Qty

Loc Code

WA

571.35808

117197

102.9036

117896

53.3264

118153

82.2683

118248

33.0983

118597

73.01888

118955

226.7426

AN3-10A

Purchased

No

150

Each

182.0000

6

6



Bolt



6  
SP

Location

Loc Qty

Loc Code

GA

100

119084

100

ST351

82

117795

66

119128

16

AN960JD8

NAS1149DN832J Purchased

No

150

Each

0.0000

2

2



Washer

D2931

Manufactured

No

150

Each

578.0000

2

2



Bumper



11/10/13

Location

Loc Qty

Loc Code

ST504

578

46064

578

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Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each

34.0000 2



Blanking Plate



2

Location

Loc Qty

Loc Code

GA

34

73478

34

MS20600-AD4W3

Purchased

No

150 Each

1,457.000 2



2

2

Cherry Rivets

Location

Loc Qty

Loc Code

GA

920

118626

920

ST321

404

111636

48

117505

321

117601

35

WA018

133

107939

133

MS21042L3

Purchased

No

150 Each

11,160.00 6



6

Nut

Location

Loc Qty

Loc Code

ST300

2160

117441

16

117601

68

117885

97

118451

979

118927

1000

ST516

6000

119017

6000

ST518

3000

119075

3000

6

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Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

74.0000

12

12



1119225 11/10/13

WASHER

Location

Loc Qty

Loc Code

ST275

74

117735

63

118354

8

17317

3

Tuesday, October 04, 2011 1:42:16 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

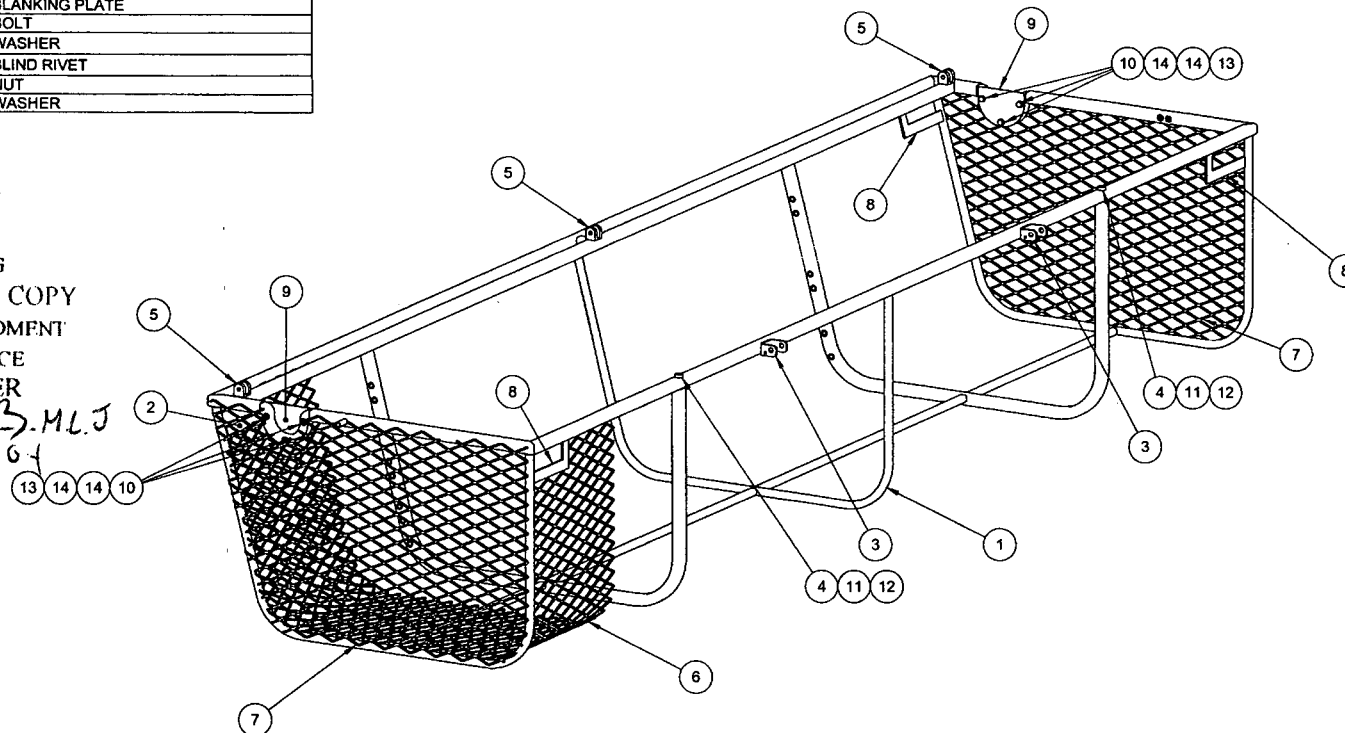
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 74633.MLJ  
11/10/64



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-03-22  
JWP

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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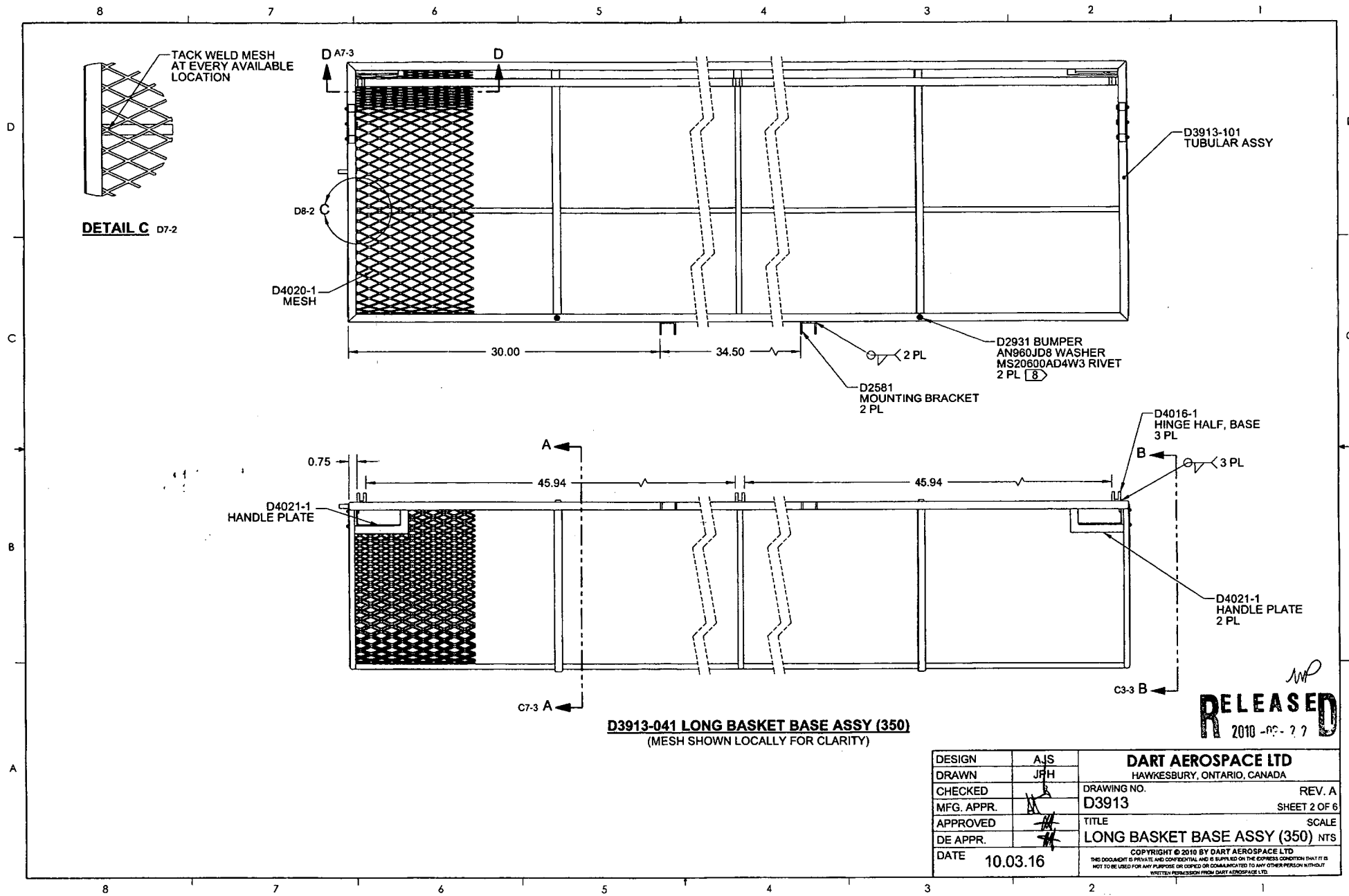
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

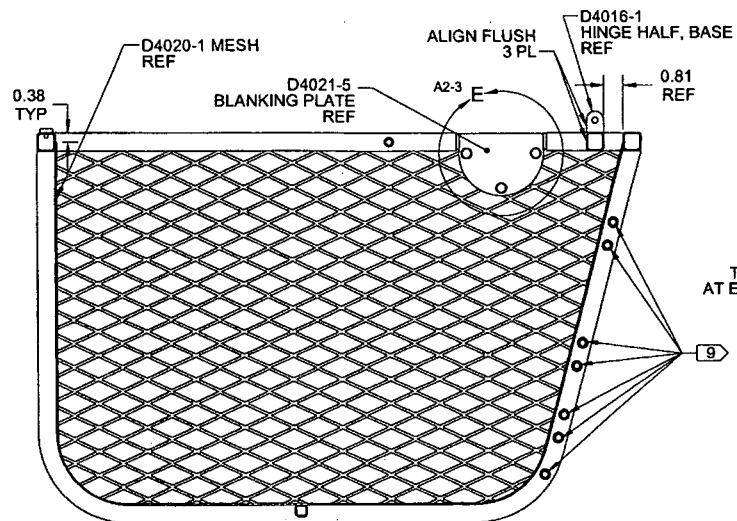
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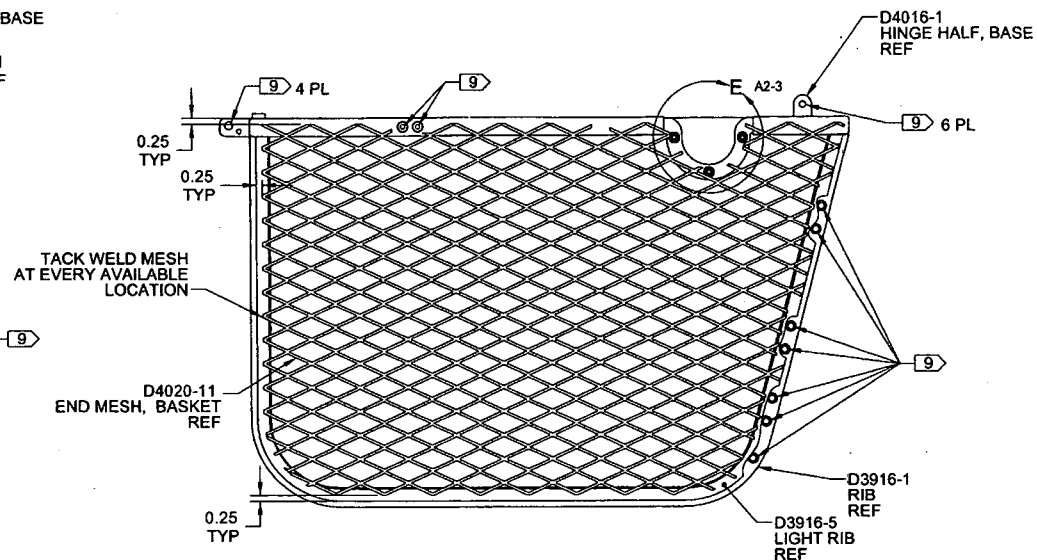
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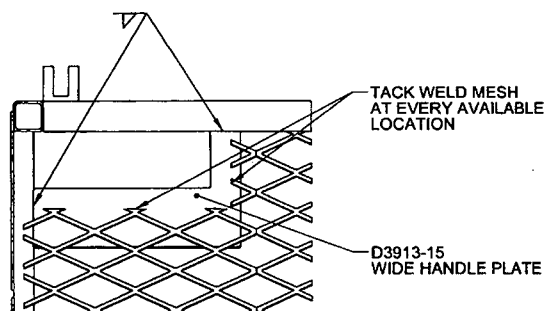
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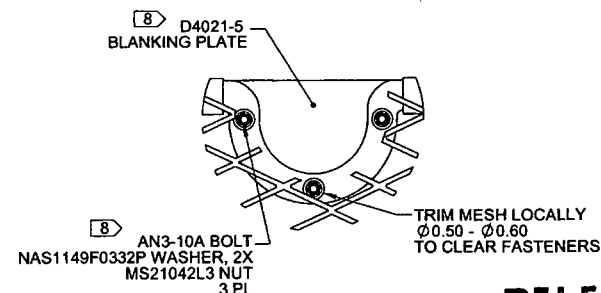
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL E** D2-3  
D6-3

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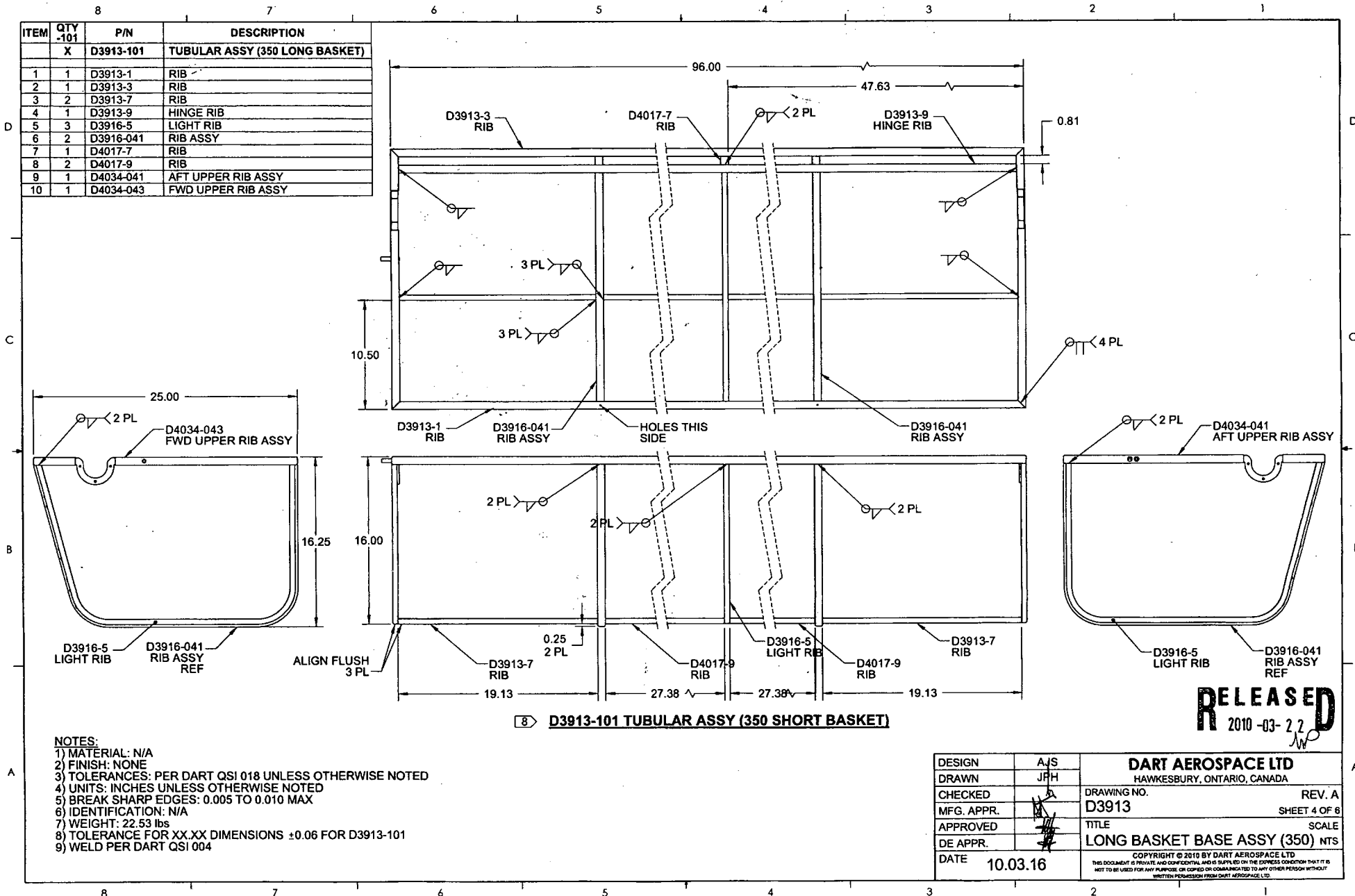
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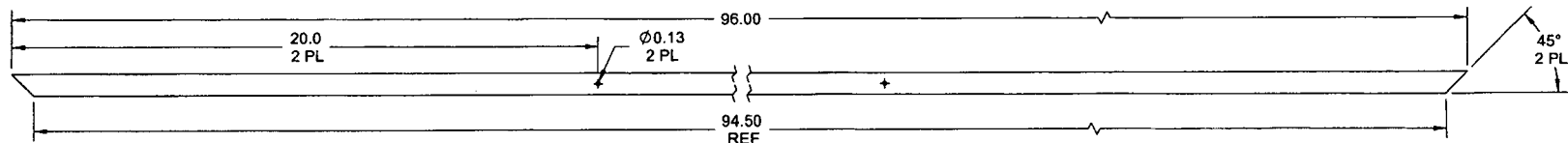
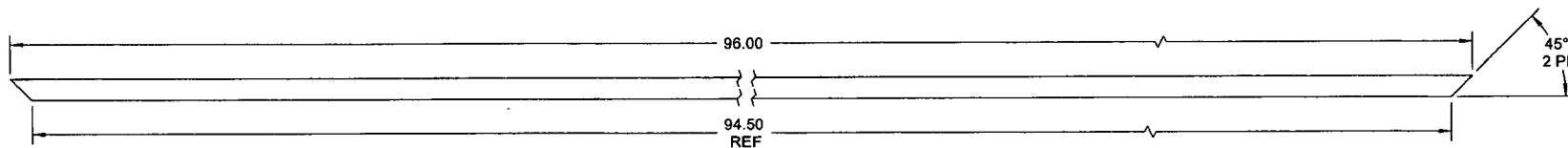
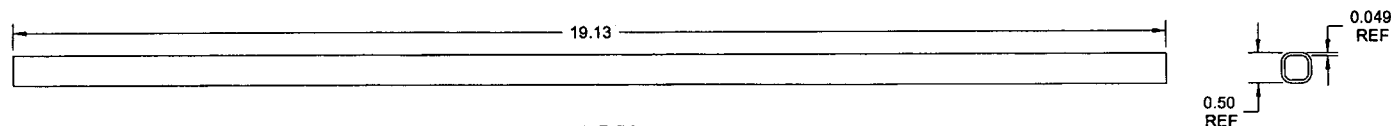
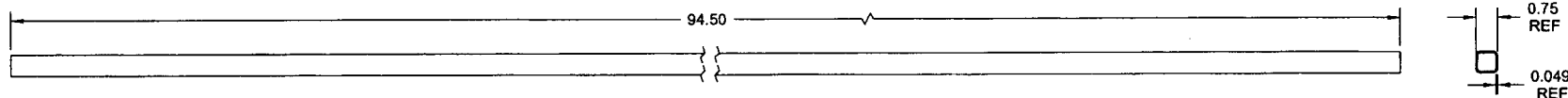
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**D3913-1 RIB****D3913-3 RIB****D3913-7 RIB****D3913-9 HINGE RIB****NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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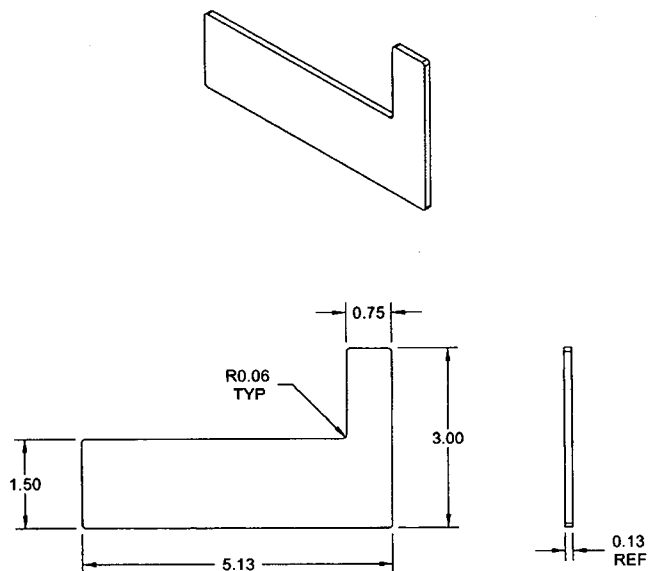
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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MFG. APPR.	<i>[Signature]</i>	D3913	SHEET 6 OF 6
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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